Quality Control

Work Ord October-19-12		966		*910					Page 1			
Revision ID:	D350-689-0 Shoulder Har	ness (4 point inertia ree	:l)	Accept	*N900	<u>040</u>	100)* ፡	Setup	Start Stop	1/1	S1* S2*
	10/18/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	D:						
Approvals:		an: MLJ	Date: \2-\0-2			ate:		I		Start Stop	171	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
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*110 *110* Packaging Packaging		Pick Kit Memo		0.00								12/10/24
¹²⁰ *12∩*		QC4- 100% Inspect kit	s for completeness	0.00 AS	12/10/24							
QC		Memo		0.00	\" \							

NCR:	Yes / No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	QA Closed	: Dat	te:	
Work Ord	er·				DISPOSITION				AGAINST DE	PARTMEN'	T/PROCESS		
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. ore/Packaging Supplier		eering Quality Other
Root					ption of work order update		nitial		tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n QC	Inspector
Doc/Data Equip/Tooling Operator Material Setup													
Other						1							
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,	Bending Centre N Cracks	lot Conce	ntric to C)/s	Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Unde Part Incorr	er tolerance ect	—	e/Forced ature/Cure
	Crushed	/Crimped.			Burrs			tions Incomplete/	Unclear	Part Lost/N	Missing	Wrong	Stock Pulled
	Cuffs	·			Contamination		Mainte			Part Move	d '		
	Heat Tre	at			Countersink		Mislabe	eled		Positioned	Wrong		
	Inspection	on Strip in	Tube		Cut Too Short		Misread	t		Power Loss	S/Surge	Other	
	Ripples i	n Bend			Drill Holes ,		Offset						
	Torque \	Vaves in E	xtrusion		Drawing		Out of 0	Calibration					
		Sequence		1	Finish		Out of S	Sequence					
	Wave/Tv	vist in Tub	oe .		Folio		Outside	Dimensions					

__Date:

DQA:

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QC21- Final Inspection - Work Order Release

PPP Rev:

0.00

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Memo

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Quality Control

M512-10-26

Insp.

Page 2

										DQA:	Date:	P * 5
NCR:	Yes / N	0			WORK ORDER NON-	·CO	NFORM	MANCE / UPI	DATE	QA Closed:	Date:	
Mork Ord		•			DISPOSITION	•			AGAINST DE	PARTMENT	/PROCESS	
Work Order Part N	No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier						Engineering Quality Other
Root					ption of work order update	-	Initial		ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector
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Landii	ng Gear				General							
	Bendin	g			Bend		Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	_		Burrs		Instruct	ions Incomplete/l	Jnclear -	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs	•			Contamination		Mainte	•		Part Moved		-
	Heat Ti	eat			Countersink		Mislabe	led		Positioned \	Vrong	
ŀ	Inspect	ion Strip in	Tube		Cut Too Short		Misread		<u> </u>	Power Loss/	· ·	Other
1		in Bend			Drill Holes		Offset		<u> </u>	.		1
		Waves in E	extrusion	, 	Drawing		4	Calibration				

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

Picklist Print

October-19-12 2:57:11 PM

Work Order ID:

91966

Parent Item:

D350-689-017

Parent Item Name:

Shoulder Harness (4 point inertia reel)

Start Date: 10/18/12

Required Date: 11/09/12

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ANS-IA		Purchased	No			110	Each	38.0000	2	2	jp		
				Location		Loc Qty	Lo	c Code			,	Oi K	
				ST337		38						SME	>
					408	38			. /0	8408			
D4071-041 Shoulder Harness Assemb	ıly	Manufactured	No			110	Each	10.0000	3	2	28	W	
				Location		Loc Oty	<u>Lo</u>	c Code					
				ST264		6					_		
				875	05	6			87	505	S	\$\r\(\frac{1}{2}\rangle	
				ST268A		4							
				901	12	4							
Nut		Purchased	No			110	Each	1,253.0000	2	2	13		2/10
				Location		Loc Qty	Lo	oc Code			•		
				300		173							
				121	652	173				· · · · ·			
				314		1000			12	1652	•	Smi	
				122	2452	1000						~ 1N1	
				ST300		80							
					8827	4							
					5105	1			M				
					5548	43							
				115	109	20							

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NCR:	Yes / No				WORK ORDER NON-	O	VFOR	MANCE / UP	DATE		QA Closed:	Dat	e:	
					I			<u></u>		_			-	···
Work Orde	er:				DISPOSITION				AGAINST L)E	PARTMENT/ -	PROCESS		
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fal Thermoforming Finishing Large Fab Composite				4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root				Dëscrij	ption of work order update		nitial	Ac	tion		Sign &			
Cause	Date	Step	Qty	_	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	۱	QC Inspector
Doc/Data						Ì								
Equip/Tooling														
Operator														v
Material		}												
Setup				•										
Other													ļ	
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Supplier []		İ	
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Unapproved														
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Landir	ng Gear				General				-		,	,		
L	Bending				Bend		Grain		L		Ovalized		-	Pressure/Forced
	Centre No	ot Concer	ntric to (O/S	BOM/Route	L.	Hardwa	re	Ļ		Over/Under	tolerance		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	L	Inspecti	on Incomplete			Part Incorred	:t		Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
. [Cuffs				Contamination		Mainte	nance	Part Moved					
	Heat Trea	t			Countersink		Mislabe	led	Ĺ		Positioned V	/rong		
	Inspection	n Strip in	Tube		Cut Too Short		Misread				Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Picklist Print

October-19-12 2:57:11 PM

Work Order ID:

91966

Parent Item:

Washer

D350-689-017

Parent Item Name:

Shoulder Harness (4 point inertia reel)

NAS1149D0516J

Purchased

No

Start Date: 10/18/12

Required Date: 11/09/12

Start Qty: 1.00

Required Qty: 1.00

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Location	Loc Qty	Loc Code		
ST293	192			SWS
123352	192		123352	241/
ST298	9			
114797	9			

201.0000

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Each

DQA:	Date:	4	ŕ	
	-			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:			
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	· · · · · · · · · · · · · · · · · · ·			
Part No. Use NCR No. Work Order							Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root		1		Descr	iption of work order update	Initial	Α	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
опарртотсо		<u> </u>			F	AULT CATE	GORY							
Landing	g Gear				General									
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped.			o/s	Bend BOM/Route Broken/Damaged Burrs	Inspect	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear			Ovalized Pressure/F Over/Under tolerance Temperatu Part Incorrect Weld Part Lost/Missing Wrong Store				
	Cuffs Heat Treat Inspection Strip in Tube				Contamination Countersink Cut Too Short	Mainte Mislabe Misread	eled		Part Moved Positioned V Power Loss/	Vrong	Other			
-	Ripples in	Bend			Drill Holes	Offset				Juige	Joures			
	Torque W	equence) 	Drawing Finish	Out of S	Calibration Sequence							
	Wave/Tw	ist in Tub	e	1	Folio	Outside	Dimensions							